

Work Order ID 48669B

July 2, 2009 8:40:15 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID: E

Stop



Item Name: Basket Lid 205/350

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512-2-Cut (4) D2236 From
D3166-3163-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
✓
5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as
required

CP 09.07.07

HY 09/07/07

1x

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09.07.07

Work Order ID 48669B

July 2, 2009 8:40:15 AM



Item ID: D2512
Revision ID: E
Item Name: Basket Lid 205/350

Accept



Setup Start



Stop



Start Date: 7/15/09 Start Qty: 1.00
Required Date: 8/03/09 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00	27 502107107						
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat COAT: START TIME: 9:10am 460°F OVEN TEMPERATURE: 9:40am FINISH TIME: 10:30am 2ND COAT: START TIME: 10:00am 400°F OVEN TEM	0.00 0.00	M111472 09-07-08						
140 HandFinish Hand Finishing	HandFinishing Memo Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: M111013	0.00 0.00	09-07-8						

BR/5MD

Work Order ID 48669B

July 2, 2009 8:40:15 AM

Page 3

Item ID: D2512

Accept

Revision ID: E

Item Name: Basket Lid 205/350

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 1.00

Required Date: 8/03/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

~~09-07-8~~

QC

Memo

0.00

=> 09/07/09 @

Quality Control

160

Identify as per dwg & Stock Location

0.00

48669

9/7/9 @ SP



Packaging

Memo

0.00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

09/07/09 @



QC

Memo

0.00

Quality Control

11 09-07-09

Picklist Print

July 2, 2009 8:40:14 AM

Work Order ID: 48669B

Parent Item: D2512RevE

Parent Item Name: Basket Lid 205/350

Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ M304EX0.75-16F		Purchased	No			100	sf	246.5700	18.0000			

Expanded Metal Flat SS 
SAP 09-07-06



M 112147

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	246.57	
108152	90	
110134	6.7	
110292	14.4	
110629	14.41	
110861	21.18	
110992	0.58	
111444	17.79	
111630	35.15	
111956	46.36	

Date: Friday, 19/06/2009 11:23:16 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID
 Job Number : 48669B
 Estimate Number : 10193
 P.O. Number :
 This Issue : 19/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2512
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2512 REVE
 Project Number : N/A
 Previous Run : 48667B Drawing Revision : E
 Material :
 Due Date : 26/06/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF 09-06-19
 Comment : Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/
 RF
 Est Rev:N 06.04.05 Added level21 EC
 Est Rev:O 08-08-29 revE as per dwg DD verified by:EC
 Est Rev:P 08-09-24 plug holes prior to powder coating DD
 verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
		
	Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s) Pick: 3/4"x3/4" 304/316 SS tube .065" wall Batch: <u>M112051</u>	
✓ 2.0	D31663	Basket Hoop
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3166-3 Basket Hoop <u>B48429</u>	
✓ 3.0	D2506	Label Plate
		
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D2506 Label Plate <u>B45735</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:23:16 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 48669B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

✓ 4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-1

Bushing

B46325

SAD

✓ 5.0 D22321 Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-1

Hinge plate

B48230

SAD

✓ 6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B48428

SAD

09-06-19

✓ 7.0 M304EX07516F Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

18 sf M304EX0.75-16F Expanded Metal

M112147

SAD

09-07-06

①

✓ 8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512

2-Cut (4) D2236 From D3166-3

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

5-Weld as per Dwg D2512 using Dt9436

SAD 09-07-06

SAD 09-07-06

SAD 09-07-06

SAD 09-07-06

pl 09.07.07 MS 09/07/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:23:16 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 48669B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0



QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-07-07

10.0



QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S09107/07 @

11.0



POWDER COATING

POWDER COATING



Comment: POWDER COATING

M 111472

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

9:40 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

9:40 AM

2ND COAT:

START TIME:

10:00 AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

10:30 AM

111 09-07-08

12.0



HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

M 110907

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Batch:

111013 MD/BR 09-07-8

13.0



QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

S09107/09 @

14.0



PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:23:16 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 48669B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0



QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

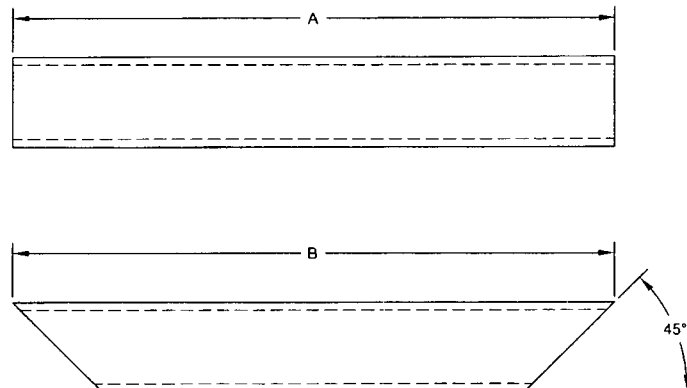
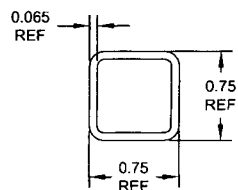
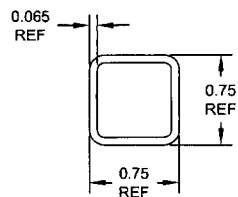
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



RELEASED
08-08-21/17

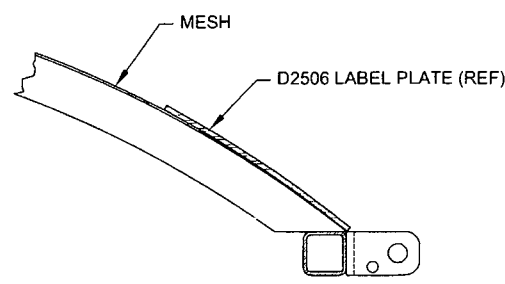
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS. INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSES UNLESS IT IS SPECIFICALLY AUTHORIZED BY DART AEROSPACE LTD.	

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

48669B

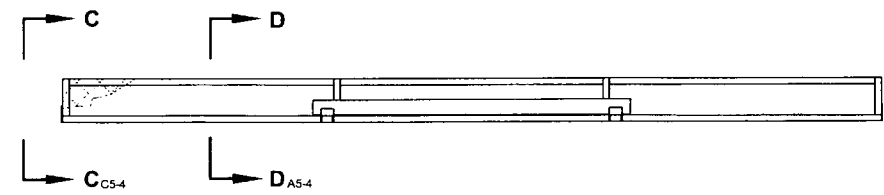
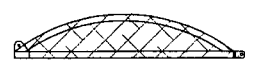
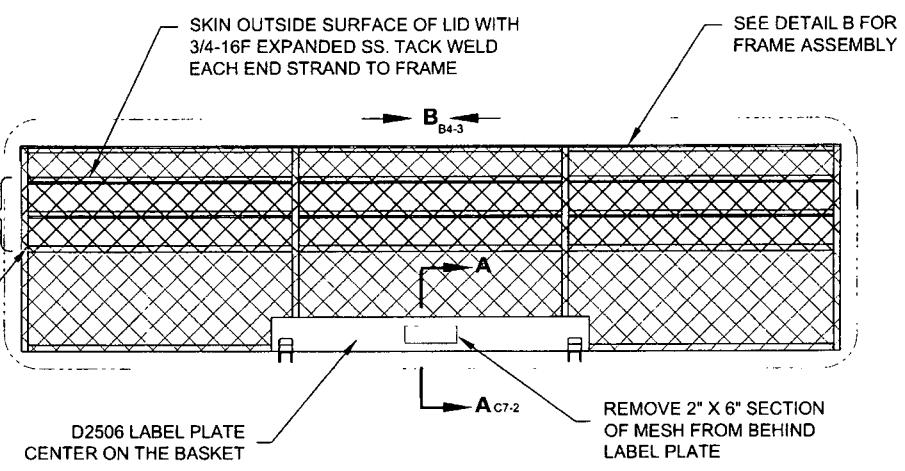
8 7 6 5 4 3 2 1



SECTION A-A B3-2
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

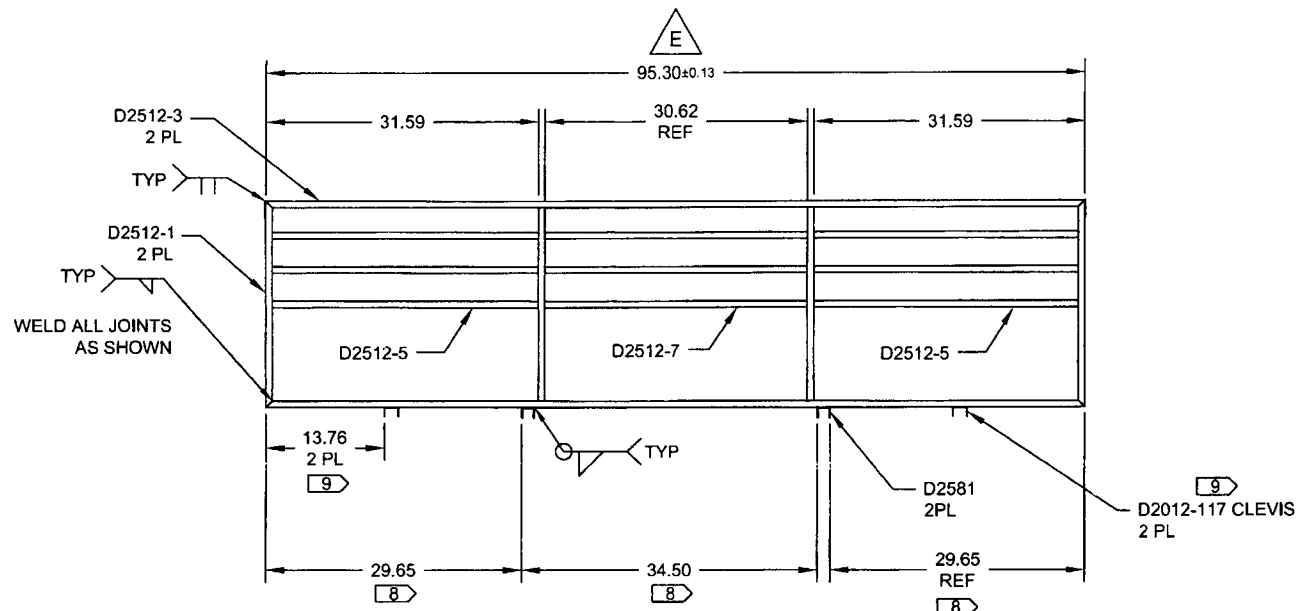
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

48669B

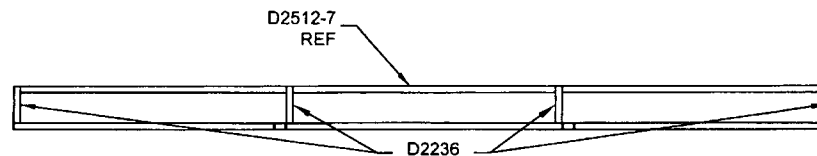
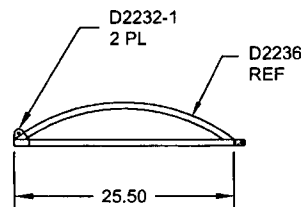
RELEASED
05 05-21/10

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1







DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



NOTES:

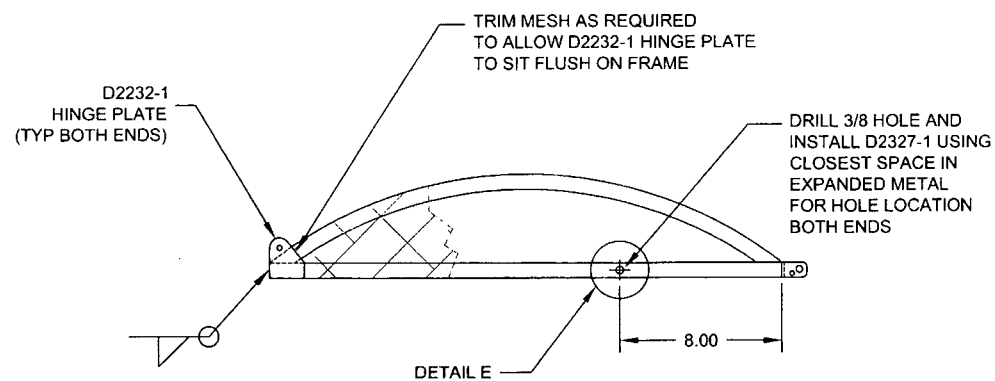
- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

RELEASED
08 06 17

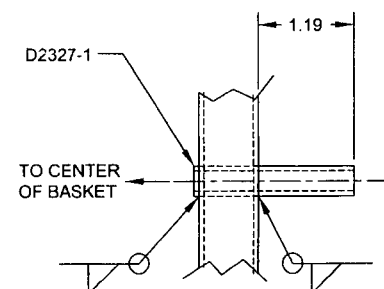
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
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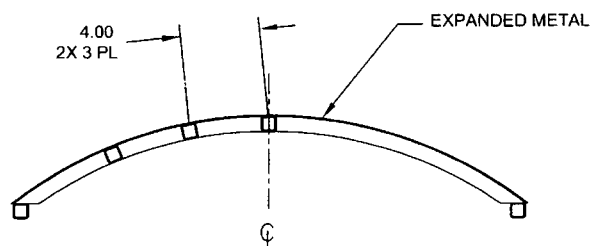
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VIEW C-C SIMILAR BOTH END RIBS A5-2



DETAIL E C6-4



SECTION D-D SAME BOTH CENTER RIBS A4-2

RELEASED
08-06-17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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